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D3294-1

Job Sheet 192236

Part No: D3294-1

Job Qty: 10 ea

Part Name: Bracket For Interior Window For -115

Part Weight: 0 lbs

Job Created: 3/19/19

Due Date: 4/18/19

Type: SOLD

Status: New

Priority: Medium

Job Tracking No:

Created By: Marie Lajeunesse

Description:

Note: DWG REV D IPP A 04.08.24 New issue KJ/JLM IPP Rev:B Now On Waterjet 07-03-26 JLM IPP Rev:C 08-07-16 Redesign part DD verified by:EC IPP Rev:D 08-10-06 revB as per dwg DD verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	10 pcs	4/18/19	4/18/19	0.00	3.21	Waterjet - Flow		JRB 6/26/19
110	QC	10 pcs	4/18/19	4/18/19	0.00	0.00	QC2 Waterjet-1		JRB 6/28/19
120	QC	10 pcs	4/18/19	4/18/19	0.00	0.00	QC8-2		01 0 2 2019 40
130	Brake NC	10 pcs	4/18/19	4/18/19	0.08	1.38	Brake NC 1		9-89
140	QC	10 pcs	4/18/19	4/18/19	0.00	0.00	QC5		40
150	HandFinish	10 pcs	4/18/19	4/18/19	0.00	0.76	HandFinish1		01 0 3 2019
160	QC	10 pcs	4/18/19	4/18/19	0.00	0.00	QC7-2		01 0 4 2019
170	Small Fab	10 pcs	4/18/19	4/18/19	0.00	1.57	Small Fab-3		01 0 4 2019
180	QC	10 pcs	4/18/19	4/18/19	0.00	0.00	QC5		58 SEP 2 0 2019 DAS
190	Powdercoat	10 pcs	4/18/19	4/18/19	0.00	0.44	Powdercoat4		SEP 2 6 2019 68
200	QC	10 pcs	4/18/19	4/18/19	0.00	0.00	QC3		BR 9-27 9-89
210	Packaging	10 pcs	4/18/19	4/18/19	0.00	0.00	Packaging3-1		SEP 3 0 2019 9-89
220	QC21-SA	10 Ea	4/18/19	4/18/19	0.00	0.00	QC21		74 SEP 3 0 2019 9-89

Part Op 100 - 1-Cut as per Dwg D3294 CUT File D3294-3 Dwg Rev: D Prog Rev: D *grain direction on a 45 deg as

Descriptions: per dwg** 2-Deburr if necessary

130 - 1-Deburr if necessary 2-Bend as per Dwg D3294 (Ensure angle is correct)

170 - 1-Install D3294-5 doubler to D3294-3 bracket with rivets as per dwg. D3294

190 - Start Time: 7:00 Oven Temperature: 320 Finish Time: 8:30 11/15/19

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M2024T3S.080	2024-T3 .080 Sheet	18 sf (1.8 ea)	100-Waterjet - Flow - 1	5153358
D3294-5	Doubler	10 pcs (1 ea)	170-Small Fab	5194386
MS20470AD4-5	Rivet, Universal Head	150 Ea (15 ea)	170-Small Fab	5049829-1

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M2024T3S.080	18	55	0
170-Small Fab	D3294-5	10	4	0
	MS20470AD4-5	150	1,844	0

Part Specifications
Specifications could not be found.

Plex 3/19/19 2:50 PM Dart.lajeunesse.marie

DART AEROSPACE LTD		Work Order: 192236
Description: Bracket Assembly		Part Number: D3294-1
Inspection Dwg: D3294	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	0.130			VDC-02 Tape	
Ø0.141	+0.005/-0.001	0.142				
6.708	+/-0.010	6.708				
1.118	+/-0.010	1.113				
5.590	+/-0.010	5.595				
1.118	+/-0.010	1.113				
13.563	+/-0.010	13.560				
1.043	+/-0.010	1.043				
0.625	+/-0.010	0.629				
0.325	+/-0.010	0.326				
0.300	+/-0.010	0.302				
0.400	+/-0.010	0.401				
6.000	+/-0.010	6.003				
1.000	+/-0.010	0.996				
17.124	+/-0.010	17.124				
16.13	+/-0.030	16.13				
7.27	+/-0.030	7.27				
11.97	+/-0.030	11.97				
8.37	+/-0.030	8.39				
20.05	+/-0.030	20.04				
12.98	+/-0.030	12.99				
14.59	+/-0.030	14.59				
11.66	+/-0.030	11.66				
0.080	+/-0.010	0.081				

Measured by: SRB	Audited by: DAS 40 9-89	Preliminary Approval:
Date: 6/28/19	Date: JUL 02 2019	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.24	New Issue	KJ/JLM	
B	06.03.09	Dimension 12.97 was 13.03	KJ/JLM	
C	08.11.27	Dimensions updated per Dwg Rev B	KJ/EC	
D	09.07.29	Dimension 2.100 was 2.072	KJ	
E	09.09.14	Dimensions updated per Dwg Rev C	KJ	
F	13.05.08	Dwg Rev updated	KJ	

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No.

Route update only

[illegible]